

Work Order ID 137078-2

137078

Page 1

Thursday, September 24, 2015 2:08:04 PM

Item ID: 647.7601

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lower Deflector Assembly

Start Date: 10/13/15 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 10/13/15 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
647.7600	NC

110 Pick Kit

0.00

DAS

110

30
9-89

Packaging Memo 0.00

Packaging

120

0.00

120

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 5.

A/R RTV LOCTITE 598: M133275
exp. date: 05/17

130

QC5- Inspect part completeness to step on W/O

0.00

DAS
30
9-89

130

QC

Memo

0.00

Quality Control

OCT 13 2015

Work Order ID 137078

Thursday, September 24, 2015 2:08:04 PM

137078

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Item ID: 647.7601

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lower Deflector Assembly

Start Date: 10/13/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/13/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

Identify as per dwg & Stock Location: G.A

0.00

140

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

1X _____ 15/10/13

DAS
36
9-89

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

MF
15-10-13

Picklist Print

Page 1

Thursday, September 24, 2015 2:08:03 PM

Work Order ID: 137078

137078

Parent Item: 647.7601

647 7601

Parent Item Name: Lower Deflector Assembly

Start Date: 10/13/15

Required Date: 10/13/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 15-08-04 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.7611 *647 7611* Lower Deflector		Manufactured	No				Each	0.0000		1			DAS 36 9-89
								B 136946	**	(5)			
647.7612 *647 7612* Breakaway Tip		Manufactured	No				Each	0.0000		1			DAS 36 9-89
								B 136947	**	(5)			
MS20470AD6-14 *MS20470AD6-14* Rivet		Purchased	No				Each	4.0000		10 2			
									**				
													DAS 30 9-89
													OCT 07 2015

Location

Loc Qty

Loc Code

ST309

4

m130741

4

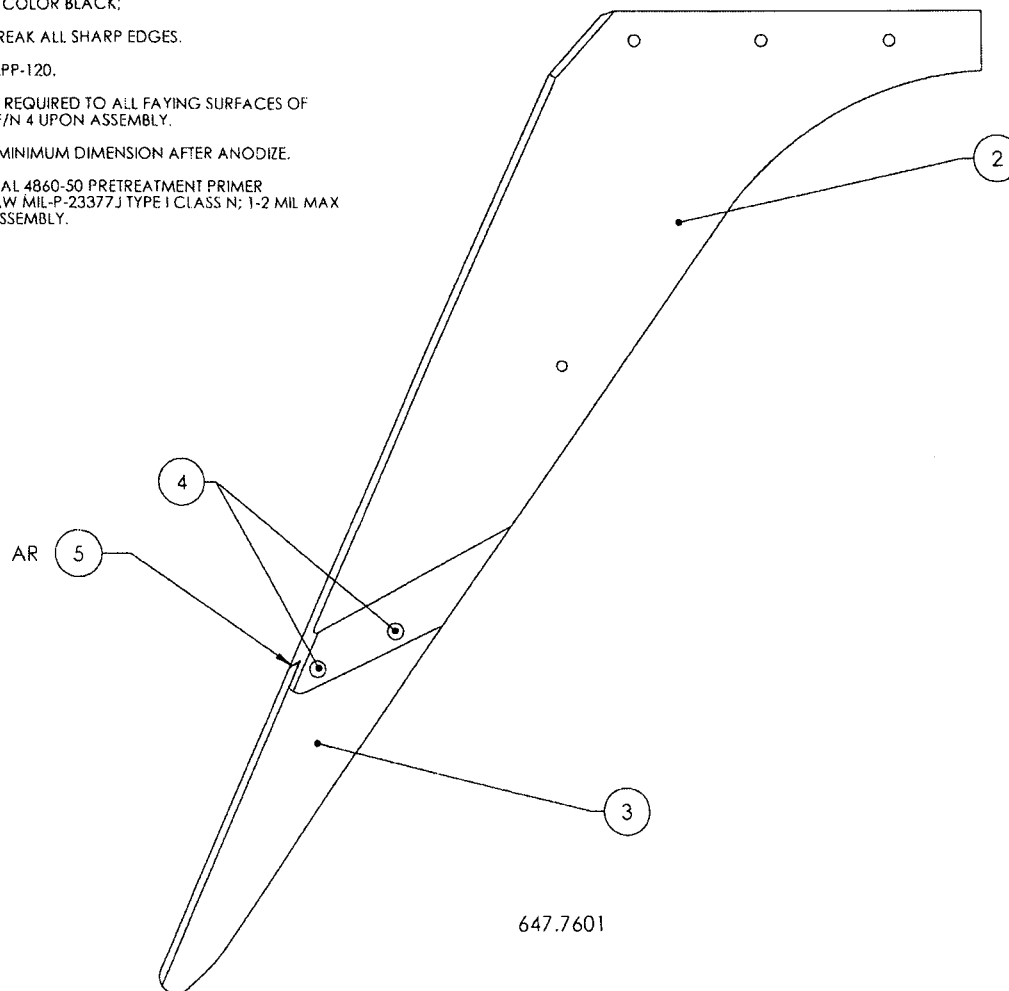
M133284

DAS
36
9-89

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NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
- 5 APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2, F/N 3 & F/N 4 UPON ASSEMBLY.
- 6 MAXIMUM OR MINIMUM DIMENSION AFTER ANODIZE.
- 7 FINISH: CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX AFTER ASSEMBLY.



REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISED: PPS		TUC
N/C	INITIAL RELEASE	12.22.09	T. BRAYC

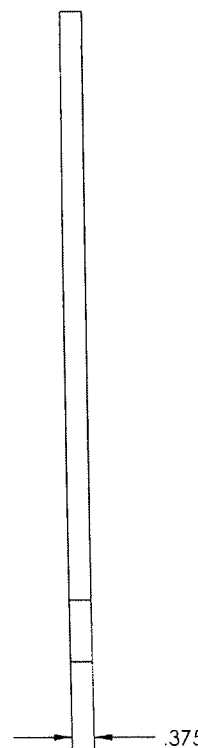
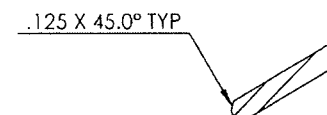
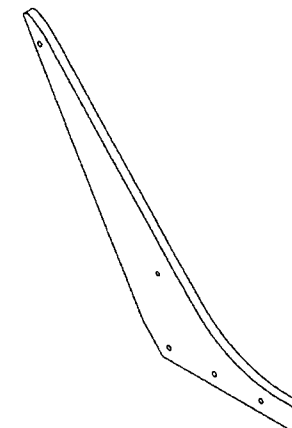
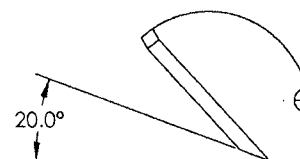
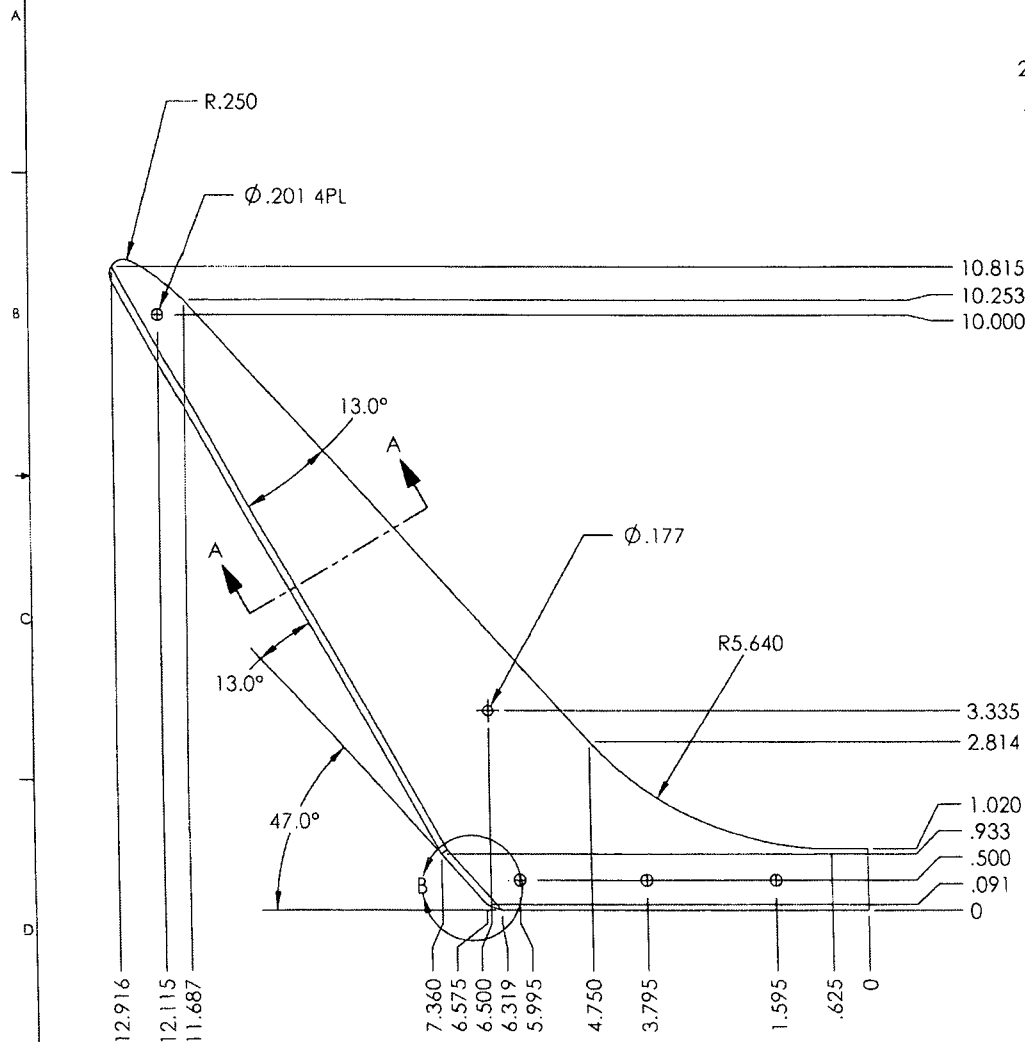
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

137078 MJS
1509-25

A/R	5	601.2045	RIV. LOCTITE 598		
2	4	601.3122	RIVET	MS20470AD6-14	
1	3	647.7612	BREAKAWAY TIP	1	2
1	2	647.7611	LOWER DEFLECTOR	1	2
	1	647.7610	UPPER DEFLECTOR	1	2, 3, 4
		647.7601	LOWER DEFLECTOR ASSY		1
7601	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY			PARTS LIST		
NEXT ASSY (S)			APICAL INDUSTRIES		
647.7400			2508 TEMPLE HEIGHTS DR.		
647.7500			OCEANSIDE, CA. 92056-3512 (760)724-5300		
			DEFLECTORS		
			SCALE NONE		
			SHEET 1 OF 4		

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REV.	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE 11/24/89 DRAWN BY A. QUINN CHECKED BY P. BEAULIEU DRAWING APPROVAL 11/27/89 COMPLETED BY 11/27/89	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$	DEFLECTORS SIZE CAGE CODE DWG. NO. B 07M26 647.7600 SCALE NONE SHEET 2 OF 4

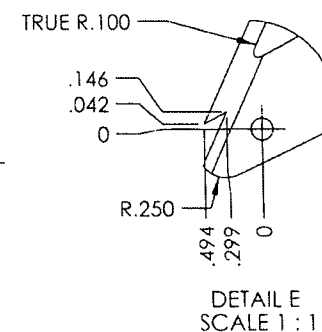
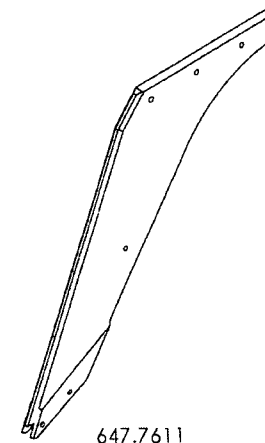
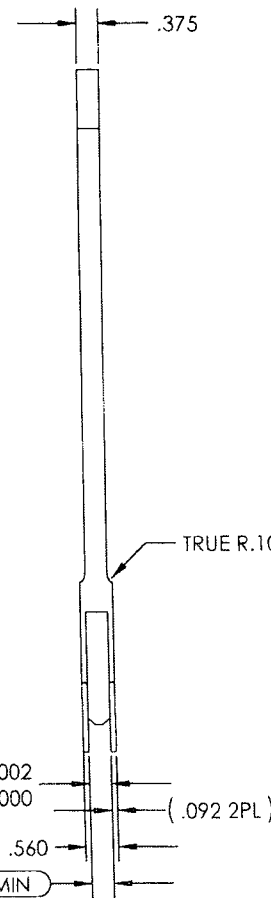
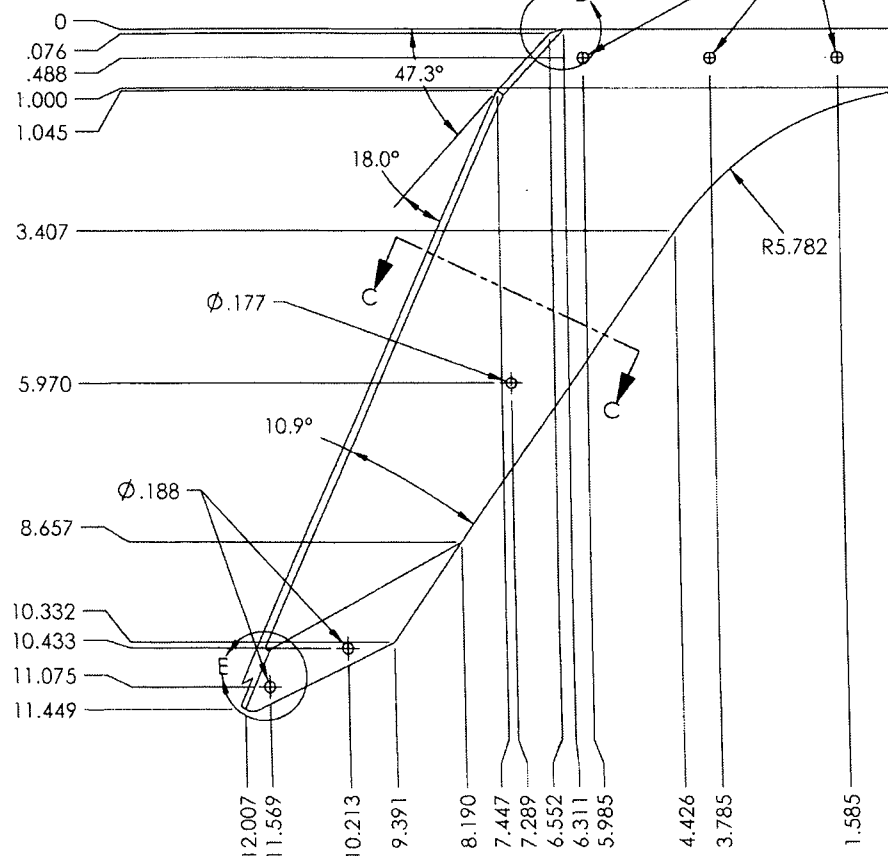
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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVE

.078 X 45.0° TYP

SECTION C-C
SCALE 1 : 2

DETAIL D
SCALE 1 : 1



ORIGINAL DATE 2002-11-15		11:22:00	
DRAWN BY A. DUAL		CHECKED P. SHAW	
DESIGNED BY P. SHAW		APPROVED 11/22/02	
CONTRACT NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-1525 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS .001 ANGLES 1°			
SHEET 1		DATE 07/14/06	QWG. NO. 647.7600
SCALE: NONE		REV. N/C	

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300
DEFLECTORS

SHEET 3 OF 4

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REV.	DESCRIPTION	DATE	APPROVED

SECTION F-F
SCALE 1 : 1.5

